

ABSTRACT

A plastic lined steel pipe characterized by having  
an adhesive layer on an inner surface of a steel pipe,  
5 having a plastic layer on its further inner side, and  
having an initial shearing adhesion strength between the  
steel pipe and the plastic layer of 2.0 MPa or more, said  
steel pipe being a steel pipe given substrate treatment  
10 on its inner surface in advance, said substrate treatment  
comprising forming a phosphate chemical treatment coating  
treated for grain refinement, and preferably having an  
epoxy primer layer between the steel pipe and the  
adhesive layer.

A method for producing a plastic lined steel pipe  
15 characterized by inserting a plastic pipe having an  
outside diameter smaller than the inside diameter of the  
steel pipe subjected to the substrate treatment and  
having an adhesive layer on its outer surface into the  
steel pipe, reducing the outside diameter of the steel  
20 pipe so as to make the plastic pipe closing contact it,  
and heating the result at a temperature not less than a  
melt end temperature of the adhesive layer and less than  
a melt start temperature of the plastic pipe.